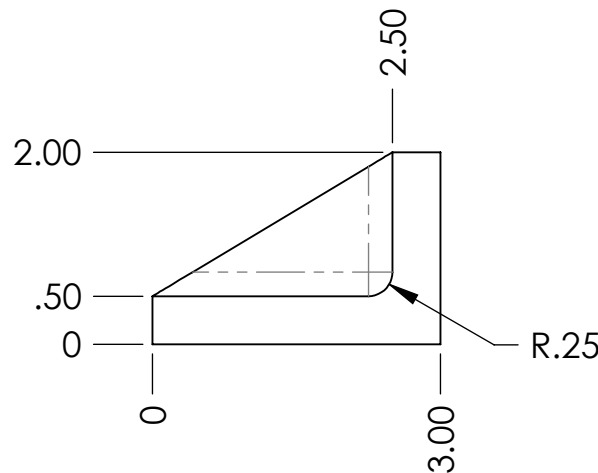
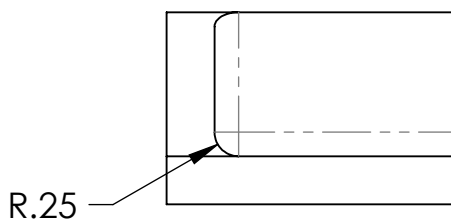
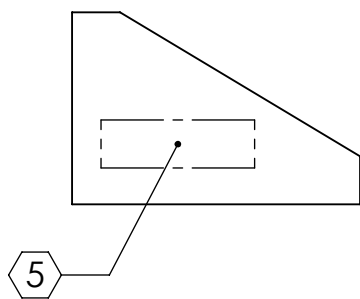
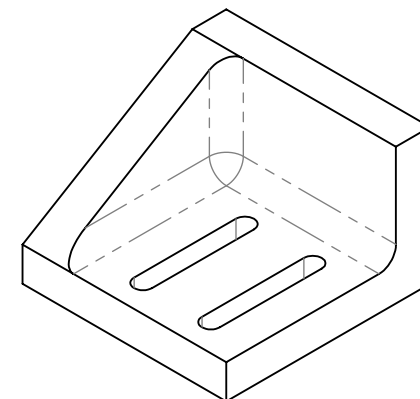
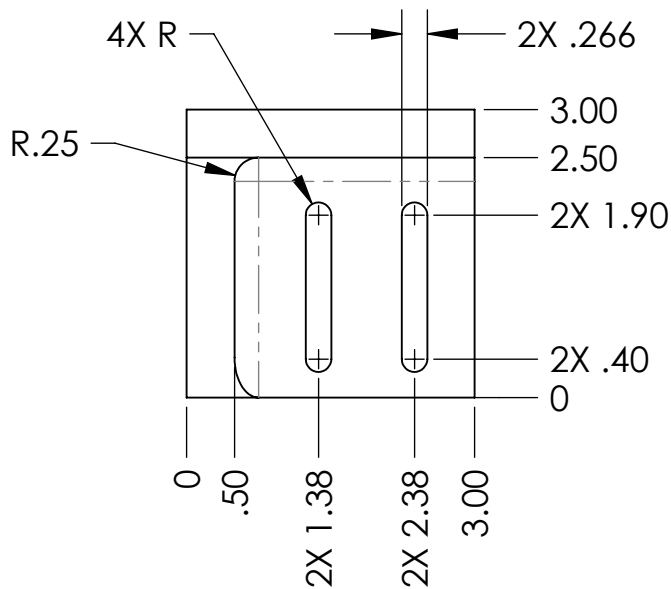


NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	15 SEP 2009	E0900302	E080191
v2	23 FEB 2011	E1100132	E080191
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005

ANGULAR ± 0.5°

- 1. INTERPRET DRAWING PER ASME Y14.5-1994.
- 2. REMOVE ALL SHARP EDGES, R.02 MIN.
- 3. DO NOT SCALE FROM DRAWING.
- 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL 6061-T6 Al

FINISH 63 μinch

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SYSTEM **ADVANCED LIGO** SUB-SYSTEM **SUS**

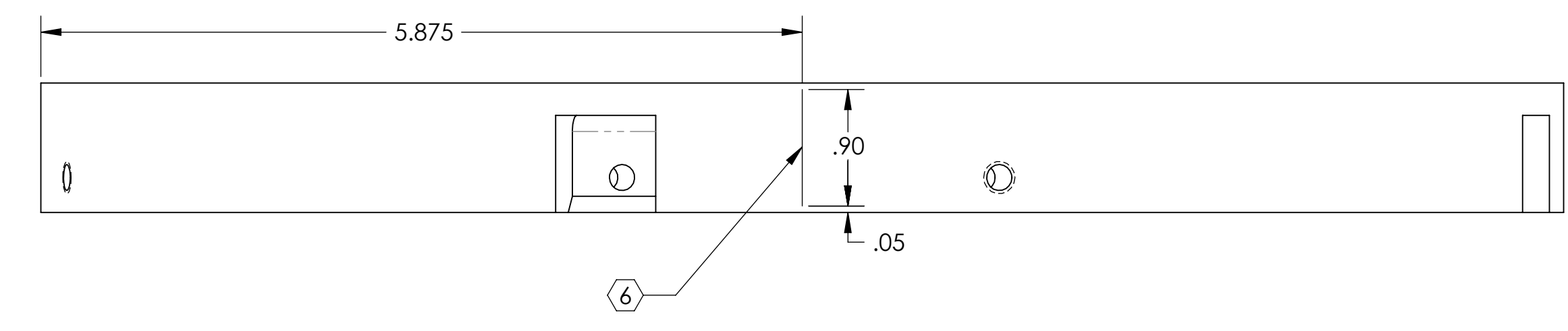
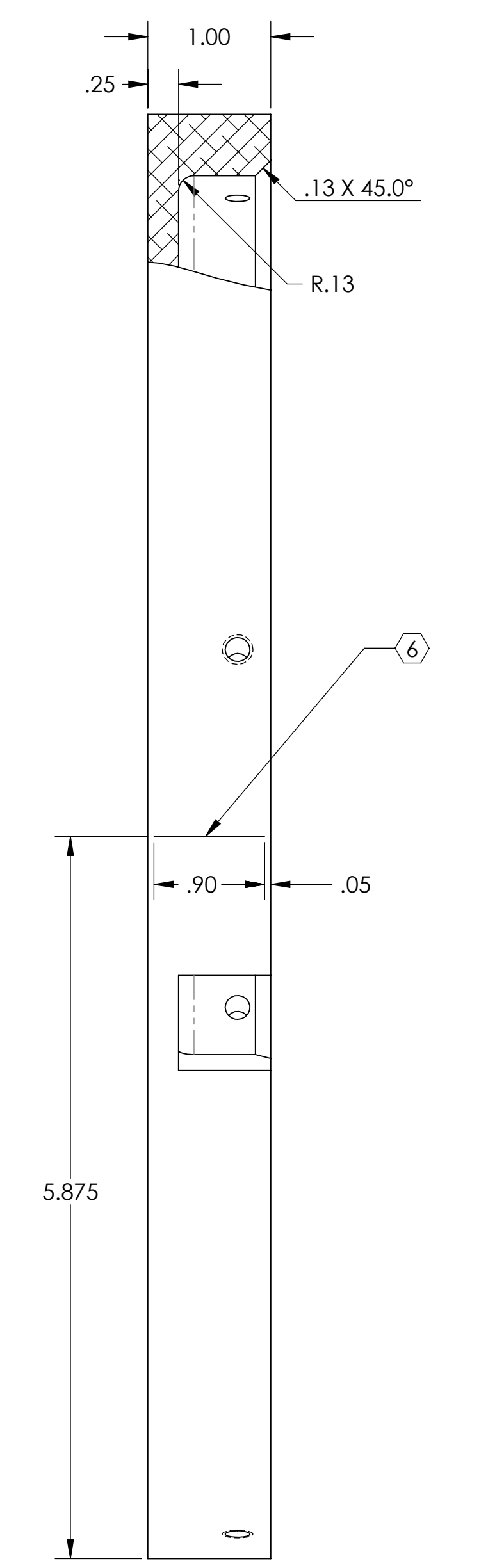
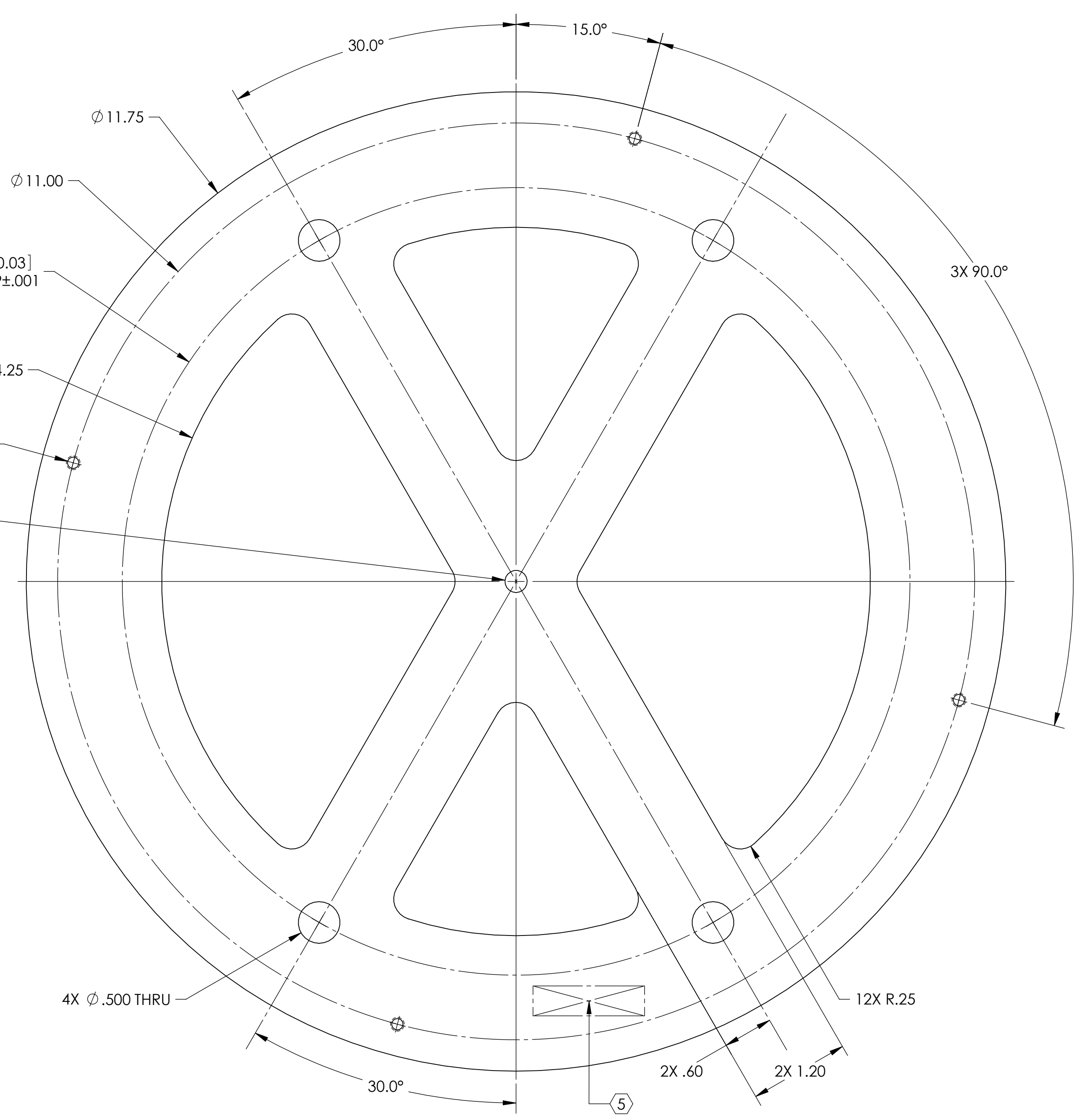
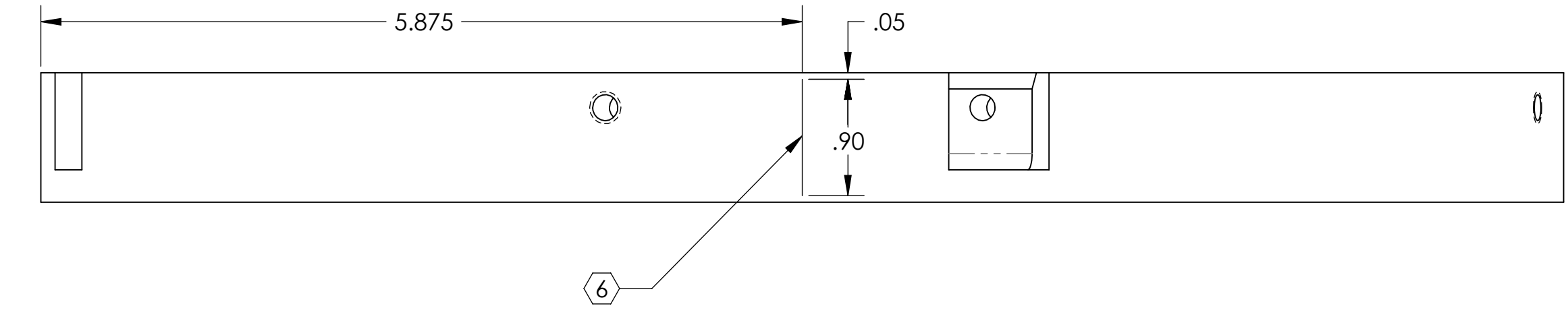
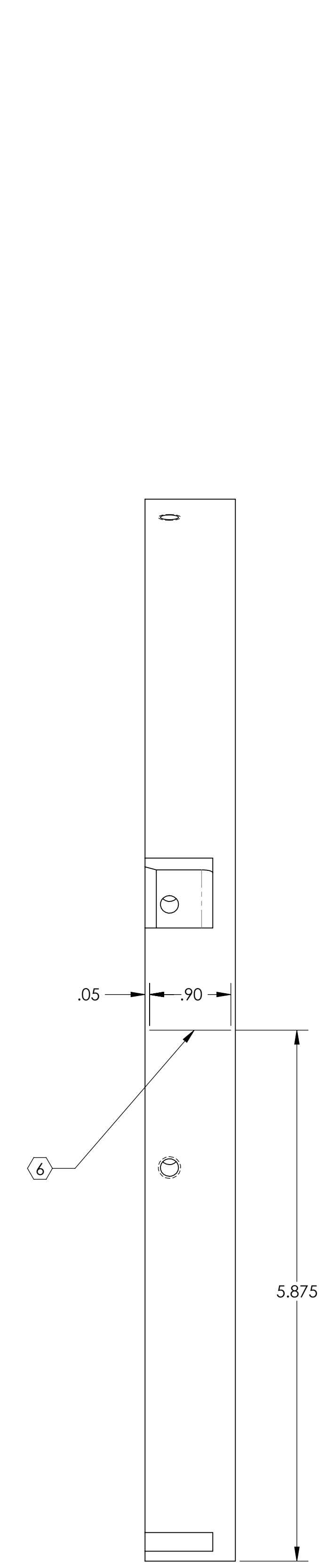
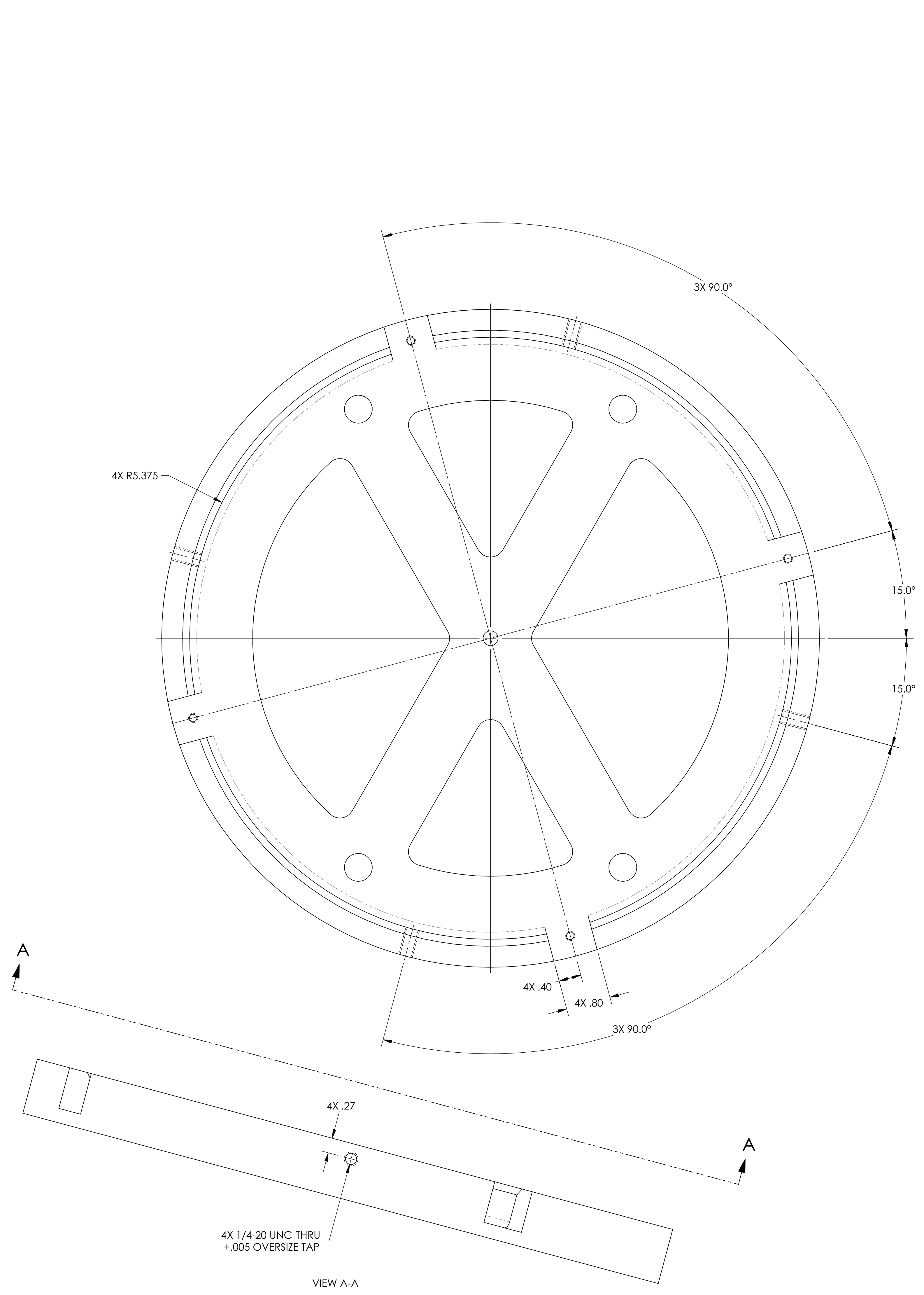
NEXT ASSY **MAGNET PLACEMENT FIXTURE, INT. MASS**

PART NAME **VERTICAL LOCATING BLOCK**

DESIGNER	D. BRIDGES	15 SEP 2009	SIZE	DWG. NO.	REV.
DRAFTER	R. BIEDENHARN	11 DEC 2010	A	D0902062	v2
CHECKER	D. BRIDGES	14 APR 2011	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1
APPROVAL					

NOTES CONTINUED:
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
 EXAMPLE: DXXXXXX-Y, TYPE-XL, SIN XXX
 6. SCRIBE OR ENGRAVE LINES AS SHOWN
 .02 MAX WIDE X .02 MAX DEEP
 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	15 SEP 2009	E0900302	E080191
v2	23 FEB 2011	E1100132	E080191
-	-	-	-

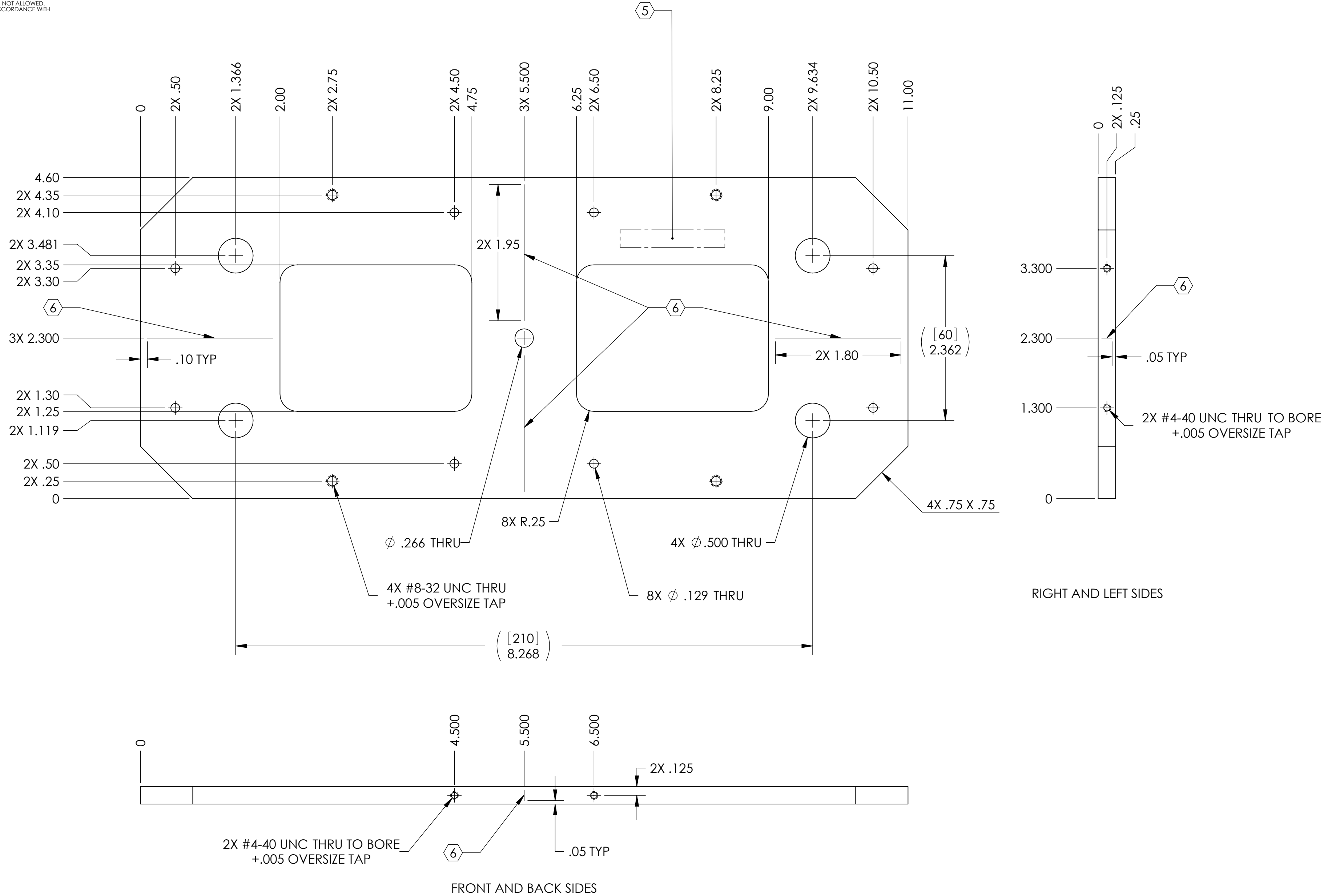


DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: XX ± .01 .XXX ± .005		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM ADVANCED LIGO		SUB-SYSTEM SUS	
ANGULAR ± 0.1°		MATERIAL 6061-T6 Al		NEXT ASSY POSITIONING STANDOFF		FINISH 63 μinch	
				DESIGNER D. BRIDGES		13 APR 2011	
				DRAFTER D. BRIDGES		14 APR 2011	
				CHECKER B. ANDRE		15 APR 2011	
				APPROVAL			
				SCALE: 1:1		PROJECTION:	
				STANDOFF RING		REV. E	
				DWG. NO. D0902068		SHEET 1 OF 1	

NOTES CONTINUED:

- ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS. UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- ⑥ SCRIBE OR ENGRAVE LINES AS SHOWN .02 MAX WIDE X .02 MAX DEEP.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	15 SEP 2009	E0900302	E080191
v2	23 FEB 2011	E1100132	E080191
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± 0.5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, R.02 MIN.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL	6061-T6 Al	FINISH	63 μinch
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SYSTEM: ADVANCED LIGO SUB-SYSTEM: SUS

NEXT ASSY: POSITIONING STANDOFF

PART NAME				STANDOFF PLATE			
DESIGNER	D. BRIDGES	14 APR 2011	SIZE	DWG. NO.	REV.		
DRAFTER	D. BRIDGES	18 APR 2011	c	D0902445	v2		
CHECKER	B. MOORE	18 APR 2011					
APPROVAL			SCALE: 1:1	PROJECTION:	SHEET 1 OF 1		

NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. SCRIBE OR ENGRAVE LINE AS SHOWN .02 MAX WIDE X .02 MAX DEEP.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	15 SEP 2009	E0900302	E080191
v2	23 FEB 2011	E1100132	E080191
-	-	-	-

D

D

C

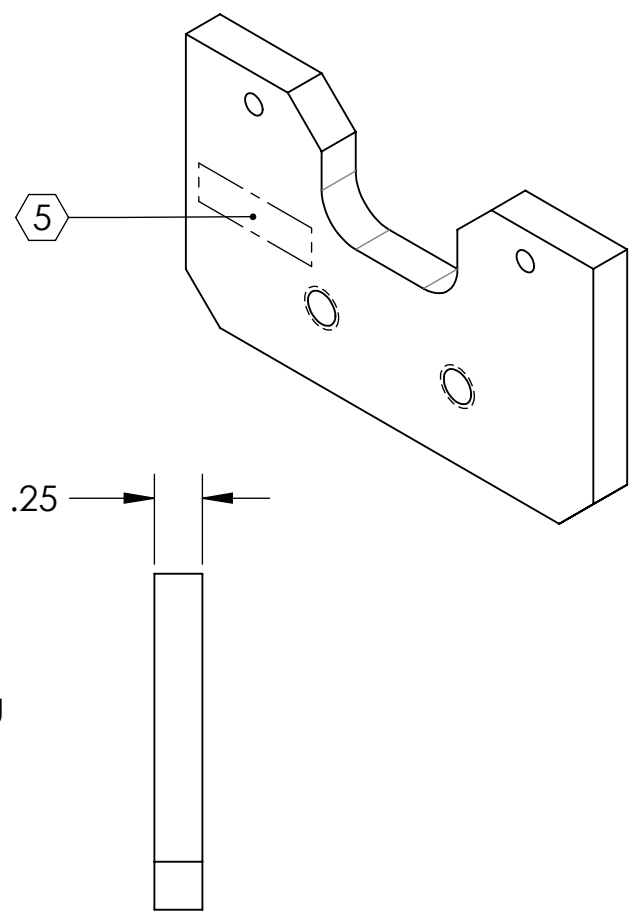
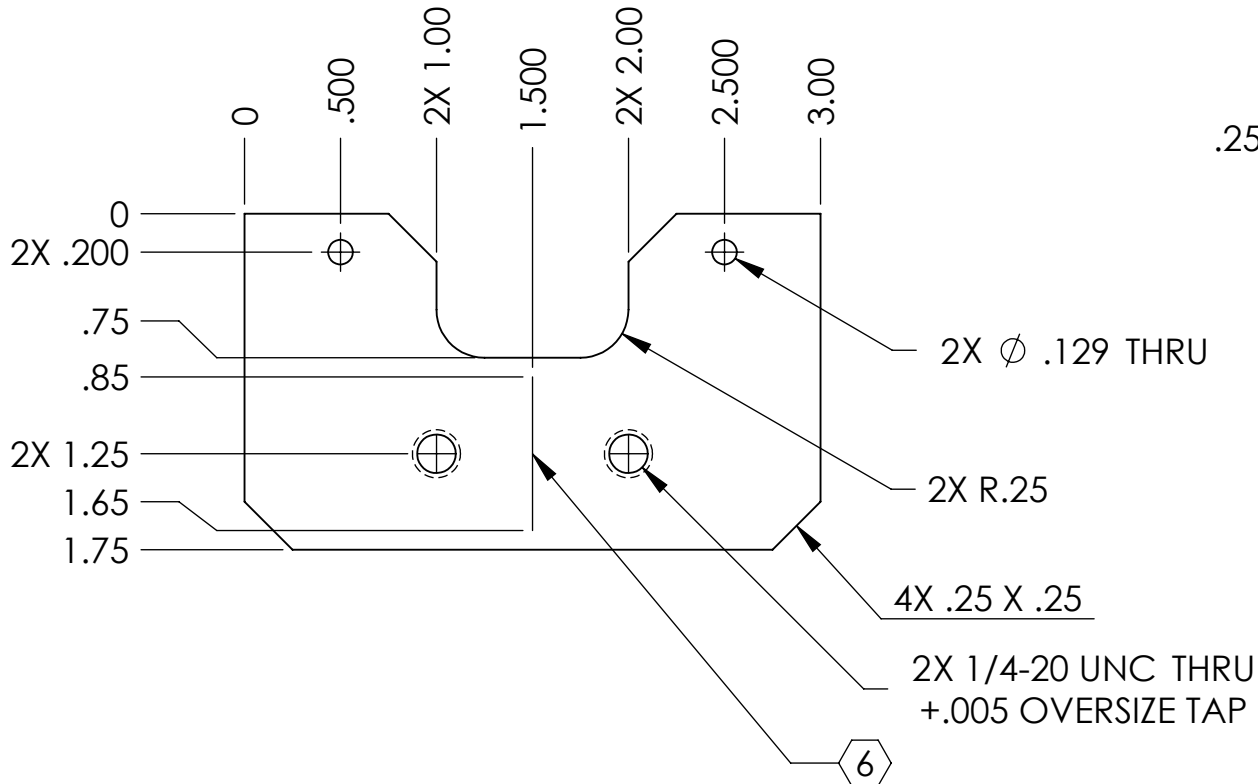
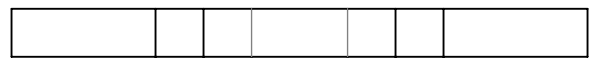
C

B

B

A

A



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES	1. INTERPRET DRAWING PER ASME Y14.5-1994.
TOLERANCES: .XX ± .01 .XXX ± .005	2. REMOVE ALL SHARP EDGES, R.02 MIN.
ANGULAR ± 0.5°	3. DO NOT SCALE FROM DRAWING.
	4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.
MATERIAL	6061-T6 Al
FINISH	63 μ inch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: SUS

NEXT ASSY: POSITIONING STANDOFF

PART NAME		STANDOFF SIDE PLATE, SHORT	
DESIGNER	D. BRIDGES	19 OCT 2009	SIZE DWG. NO.
DRAFTER	R. BIEDENHARN	11 DEC 2010	A D0902452
CHECKER	D. BRIDGES	16 APR 2011	REV. v2
APPROVAL		SCALE: 1:1	PROJECTION:
			SHEET 1 OF 1